

Work Order ID 75995

75995

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Wednesday, November 02, 2011 3:44:56 PM

Item ID: D3264-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 11/2/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/17/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *11-11-02*

Tooling:

Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3264	Rev A2								

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 5.700" LONG

amk 11/12/01

8 d

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOILIO FA447

FOLIO REV: *44*

DWG REV: *A2*

DEBURR AS PER DWG

amk 11/12/02

bo 11/12/03

8 d

75995

Wednesday, November 02, 2011 3:44:56 PM

Accept

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 11/2/2011 **Start Qty:** 8.00 ***8***

Cust Item ID:

Required Date: 11/17/2011 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

QC2- Inspect parts off machine FAI/FAIB

0.00

120

encl 11/12/02

3

QC

Memo

0.00

Quality Control

QC8- Inspect parts - second check

0,00

130

123 11. 12. 4

2

—

QC

Memo

0.00

Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00

140

8

BZ 11-12-5

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 75995

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Wednesday, November 02, 2011 3:44:56 PM

Item ID: D3264-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 11/2/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 11/17/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo								
Powder Coating									
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo								
Quality Control									
170	Identify as per dwg & Stock Location: <u>778/44</u>	0.00							
170									
Packaging	Memo								
Packaging									

Start Time: 3:20
 Temp: 3200F
 Finish Time: 3:50

8xØ m / 11/12/05

8 BR 11-12-5.

11/2/5 sl (80)

75995

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N900040100

Setup Start *NS1*

Stop ***NS2***

g

8

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**


0.00

180

QC

0.00

Quality Control

Number Stamp
11/12/6 
ME 11-12-06

Picklist Print

Wednesday, November 02, 2011 3:44:56 P

Page 1

Work Order ID: 75995

Parent Item: D3264-1

Parent Item Name: Bracket

Start Date: 11/2/2011

Required Date: 11/17/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A04.09.02New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.500 6061-T6 Bar 1.25 X 4.50		Purchased	No				f	12.7417		4			

Location

Loc Qty

Loc Code

MAT004

12.7417

112628

0.7417

→ 119230

12

4

cm 11/12/01

DART AEROSPACE LTD		Work Order: 75998
Description: Bracket		Part Number: D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.688	—		Visual	
0.063	+/-0.010	0.063	—		"	
0.125	+/-0.010	0.126	—		"	
0.875	+0.010/-0.020	0.877	—		"	
0.062	+/-0.010	0.063	—		"	
R0.03	+/-0.030	R0.03	—		"	
R0.13	+/-0.030	R0.130	—		"	
1.00	+/-0.030	1.002	—		"	
0.125	+/-0.010	0.125	—		"	
0.600	+/-0.010	0.600	—		"	
4.000	+/-0.005	4.006	—		"	
0.750	+/-0.010	0.750	—		"	
Ø0.194	+0.005/-0.000	0.195	—		"	
5.50	+/-0.030	5.500	—		"	
0.125	+/-0.010	0.127	—		"	
0.063	+/-0.010	0.063	—		"	
R0.25	+/-0.030	R0.250	—		"	
4.27	+/-0.030	4.270	—		"	
R0.30	+/-0.030	R0.30	—		"	





Measured by:	amf
Date:	11/12/02

Audited by:	RG
Date:	11.12.4

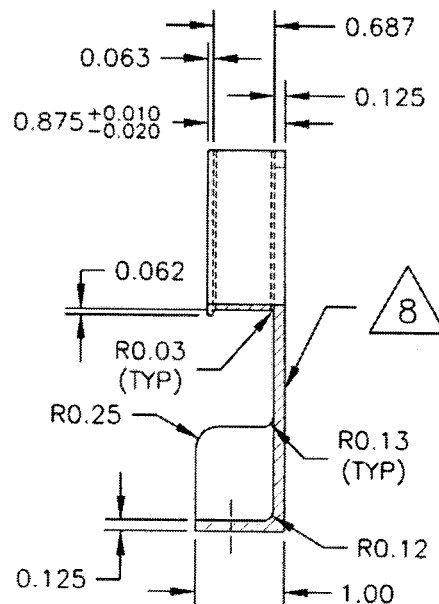
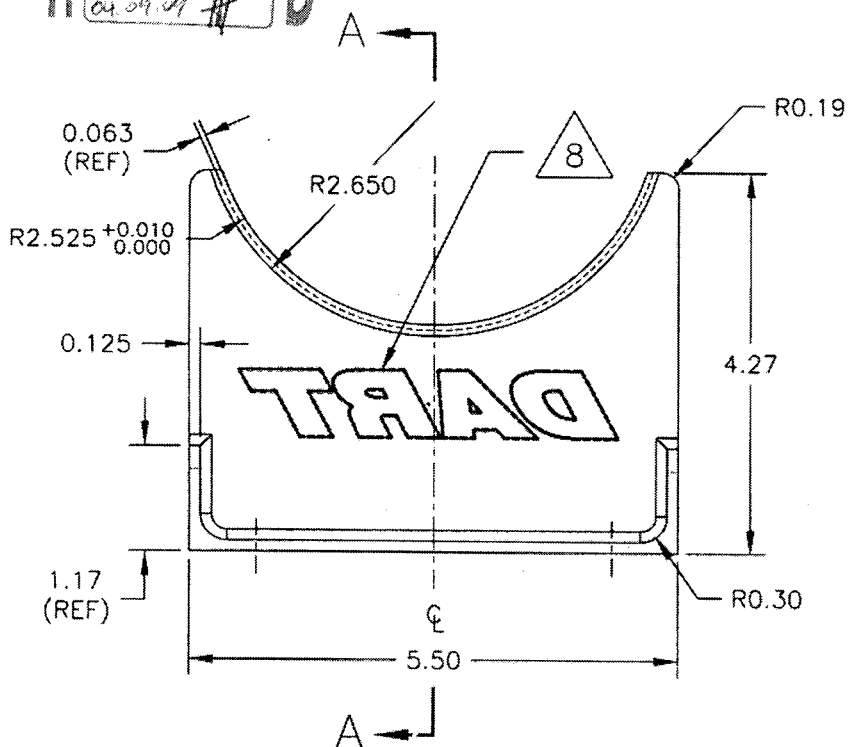
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

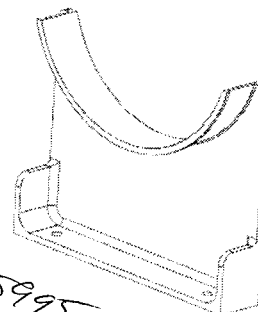
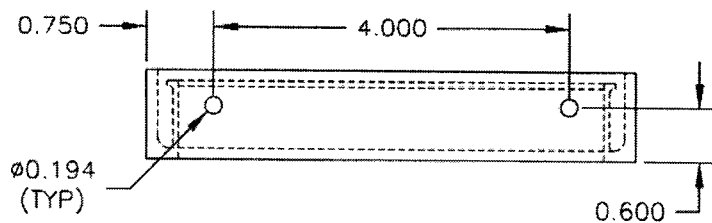


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.09.09 #



SECTION A-A



D3264-1 BRACKET

D3264-1;

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH
(MIN) TOOL RADIUS OF 0.25

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